



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3391-023**  
**Job Sheet 166956-C**



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/20/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Abu Dhabi Aviation (CABUD01)

PO Box 2723, Abu Dhabi International Airport Abu Dhabi, , 2723 United Arab Emirates ph:971 2 575 8000  
fx:971 2 575 7775.

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |            | Sign-off     |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|------------|--------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time  |              |
| 90    | Start up Operation | 1 Ea  | 12/7/17    | 12/7/17  | 0.00      | 0.00    | Start Up Skid tubes   |            |              |
| 100   | Skid tubes         | 1 pcs | 12/7/17    | 12/7/17  | 0.88      | 2.11    | Skid tubes            |            | TW           |
| 110   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC5                   |            | 17-12-424    |
| 120   | HandFinish         | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.38    | HandFinish1           |            | 2017-12-05   |
| 130   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC7                   |            | BE           |
| 140   | Skid tubes         | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 2.11    | Skid tubes            |            | 2017-12-06   |
| 150   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC5                   |            | BE           |
| 160   | Skid tubes         | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 2.11    | Skid tubes            |            | BE AP        |
| 170   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC10                  |            | PD 17-12-14  |
| 180   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC5                   |            | 17-12-14     |
| 185   | HandFinish         | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.38    | HandFinish2           |            | DEB 17/12/17 |
| 191   | Spray Paint        | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.91    | Spray Paint           | P/O. 38670 | CH 17/12/17  |
| 200   | QC                 | 1 pcs | 12/7/17    | 12/7/17  | 0.00      | 0.00    | QC14                  |            | 17/12/17     |
| 230   | HandFinish         | 1 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.38    | HandFinish4           |            | 17/12/17     |
| 240   | QC                 | 1 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.00    | QC5                   |            | 17-12-21     |
| 250   | Packaging          | 1 pcs | 12/8/17    | 12/8/17  | 0.00      | 0.00    | Packaging3            |            | SMD          |
| 260   | QC21-SA            | 1 Ea  | 12/8/17    | 12/8/17  | 0.00      | 0.00    | QC21                  |            | DEC 7 2017   |

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 hole 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skid tube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clamps to ensure perfect alignment, open up previously transfer drilled pilot holes in D3391-023/021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021 BATCH: N/A 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker. \*\*\*DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG\*\*\* Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe 140 - 1-Open float bag holes as per dwg 2-C-sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 208-04-21 batch#: M138654 NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush M137133





Mid Tube Assembly

Work Order update only ☐

**PART NO: D3391-023**  
**Revision:**  
**Operation: Start up Operation**  
**Change No:**

**Mfg Date: 11/29/17**  
**Job No: 166956-C**

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                   |                                                                                                                                                                                |                                        |
|-------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|
| Work Order: _____ | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | Skid-tube <input type="checkbox"/>     |
| Part No. _____    |                                                                                                                                                                                | Machining <input type="checkbox"/>     |
| NCR No. _____     |                                                                                                                                                                                | Thermoforming <input type="checkbox"/> |
| Date: _____       | Step #: _____                                                                                                                                                                  | QTY Effective: _____                   |

Description Work Order Deviation

**Root Cause**

|                                             |                                                |                                                 |                                                          |
|---------------------------------------------|------------------------------------------------|-------------------------------------------------|----------------------------------------------------------|
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>    | Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>              | Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                          |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>          | Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                       |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>              | Cracks <input type="checkbox"/>                 | Broken/Damage/Defec <input type="checkbox"/>             |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/>           |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>       | Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                   |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>      | Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                     |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>               | Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                   |
| LOA <input type="checkbox"/>                | Product Improvement <input type="checkbox"/>   | Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/> |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                     |
| Past Expiry Date <input type="checkbox"/>   | Manufacturing Process <input type="checkbox"/> |                                                 |                                                          |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>              |                                                 |                                                          |

OTHER: \_\_\_\_\_

|                                                |                                           |
|------------------------------------------------|-------------------------------------------|
| Mislabeled <input type="checkbox"/>            | FINISH <input type="checkbox"/>           |
| Fit/Function <input type="checkbox"/>          | Misread <input type="checkbox"/>          |
| Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/> |

185 - Re-alodine

191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: \_\_\_\_\_ PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: \_\_\_\_\_

230 - 1-Install Inserts as per Dwg

### Job Allocations

| Operation             | Component Part        | Required | Inventory | Allocated | Std Qty |
|-----------------------|-----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D2500-1-100 159717    | 1        | 90        | 0         | 0       |
| 140-Skidtubes         | D3389-1 5007579       | 1        | 3         | 0         | 0       |
| 160-Skidtubes         | D3681-1 F163491       | 5        | 135       | 0         | 0       |
| 230-HandFinish        | ALS4-1032-130 5007274 | 20       | 11,077    | 0         | 0       |
|                       | D3591-1 M1165301-108  | 2        | 85        | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 11/7/17 9:18 AM dart.poulin.mario

~ DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Step #: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Completed By                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabelled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                   |



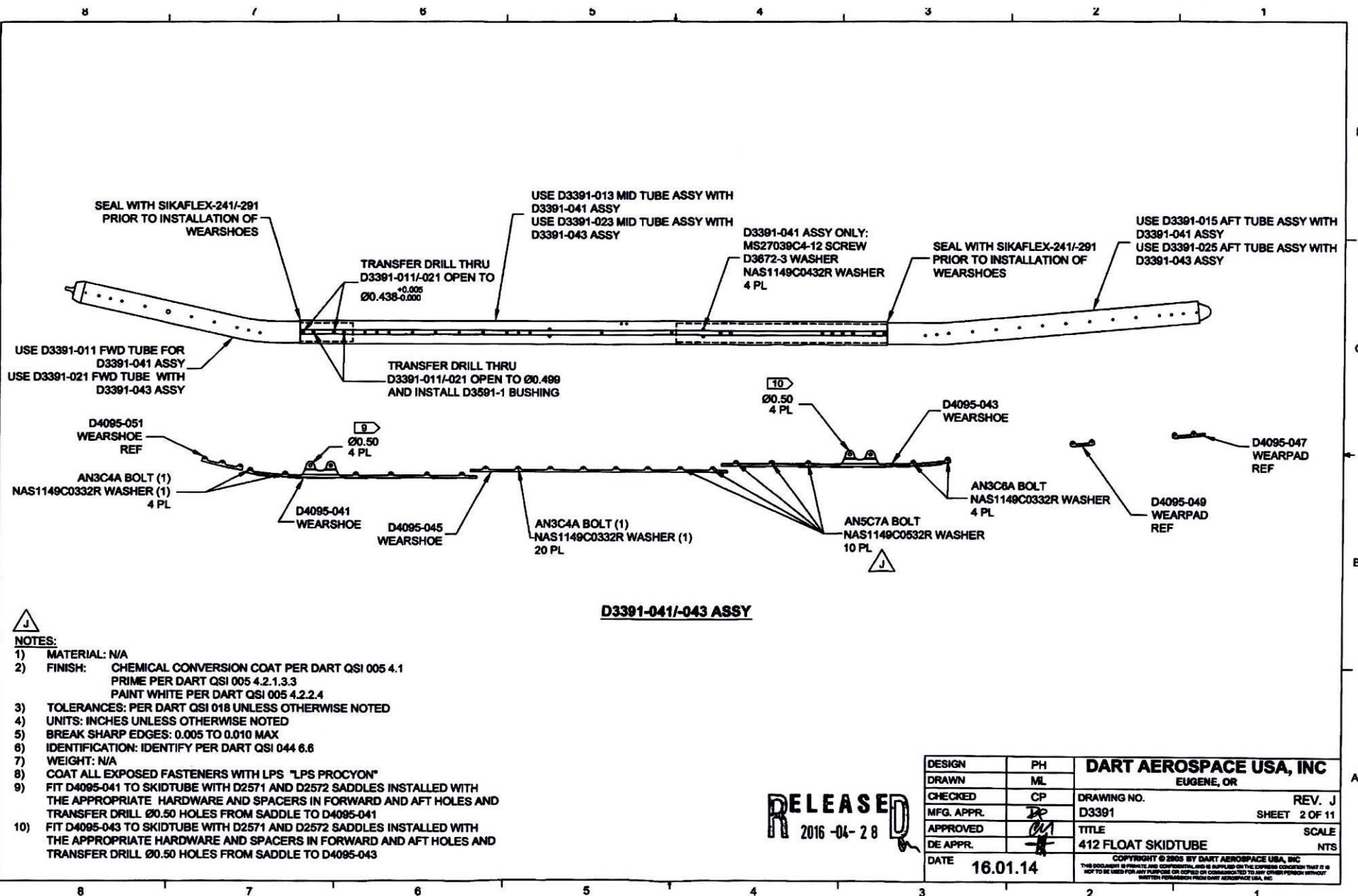
# D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

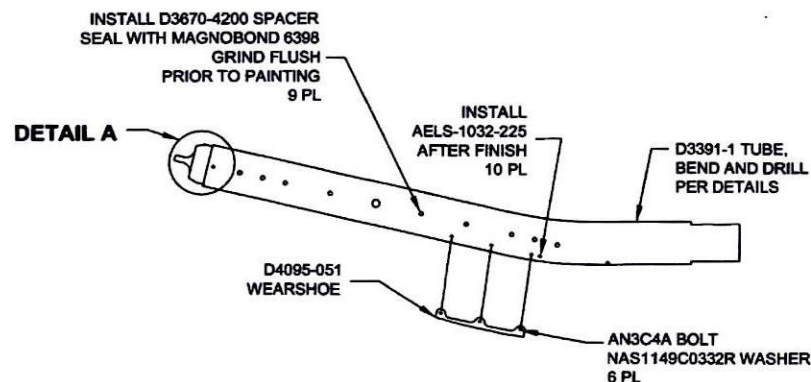
| QTY<br>-041 | QTY<br>-043 | PART NUMBER   | DESCRIPTION             |
|-------------|-------------|---------------|-------------------------|
| X           | X           | D3391-041     | FLOAT SKIDTUBE ASSEMBLY |
|             |             | D3391-043     | FLOAT SKIDTUBE ASSEMBLY |
| 1           |             | D3391-011     | FWD TUBE ASSEMBLY       |
| 1           |             | D3391-013     | MID TUBE ASSEMBLY       |
| 1           |             | D3391-015     | AFT TUBE ASSEMBLY       |
|             | 1           | D3391-021     | FWD TUBE ASSEMBLY       |
|             | 1           | D3391-023     | MID TUBE ASSEMBLY       |
|             | 1           | D3391-025     | AFT TUBE ASSEMBLY       |
| 2           | 2           | D3591-1       | BUSHING                 |
| 4           |             | D3672-3       | WASHER                  |
| 1           | 1           | D4095-041     | WEARSHOE                |
| 1           | 1           | D4095-043     | WEARSHOE                |
| 1           | 1           | D4095-045     | WEARSHOE                |
| 1           | 1           | D4095-047     | WEARSHOE                |
| 1           | 1           | D4095-049     | WEARSHOE                |
| 1           | 1           | D4095-051     | WEARSHOE                |
| 24          | 24          | AN3C4A        | BOLT                    |
| 4           | 4           | AN3C8A        | BOLT                    |
| 10          | 10          | AN5C7A        | BOLT                    |
| 28          | 28          | NAS1148C0332R | WASHER                  |
| 10          | 10          | NAS1148C0332R | WASHER                  |
| 4           |             | MS27039C4-12  | SCREW                   |
| 4           |             | NAS1148C0432R | WASHER                  |



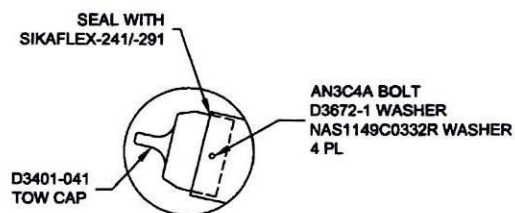
|            |                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                             |               |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| J          | INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT                                                                                                                                                         | ML                                                                                                                                                                                                                                                                                          | 16.01.14      |
| I          | REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B8-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B8-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8                      | XDF                                                                                                                                                                                                                                                                                         | 11.10.13      |
| H          | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9384 & NCR 08-074) | AJS                                                                                                                                                                                                                                                                                         | 08.08.20      |
| G          | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY                                                                                                                                                              | DC                                                                                                                                                                                                                                                                                          | 07.07.31      |
| F          | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021                                                                                                                                                                                                                             | PH                                                                                                                                                                                                                                                                                          | 07.01.18      |
| E          | CHANGE TOLERANCE, EASE MANUFACTURE                                                                                                                                                                                                                                                   | PH                                                                                                                                                                                                                                                                                          | 06.04.25      |
| D          | UPDATE TOLERANCE, CHANGE HOLE SIZE                                                                                                                                                                                                                                                   | PH                                                                                                                                                                                                                                                                                          | 06.01.23      |
| C          | LENGTHEN AFT EXTENSION                                                                                                                                                                                                                                                               | PH                                                                                                                                                                                                                                                                                          | 05.09.27      |
| B          | DRAWING UPDATES                                                                                                                                                                                                                                                                      | PH                                                                                                                                                                                                                                                                                          | 05.06.10      |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                            | PH                                                                                                                                                                                                                                                                                          | 05.02.07      |
| REV        | DESCRIPTION                                                                                                                                                                                                                                                                          | BY                                                                                                                                                                                                                                                                                          | DATE          |
| DESIGN     | PH                                                                                                                                                                                                                                                                                   | <b>DART AEROSPACE USA, INC</b><br>EUGENE, OR                                                                                                                                                                                                                                                |               |
| DRAWN      | ML                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                             |               |
| CHECKED    | CP                                                                                                                                                                                                                                                                                   | DRAWING NO.                                                                                                                                                                                                                                                                                 | REV. J        |
| MFG. APPR. | CP                                                                                                                                                                                                                                                                                   | D3391                                                                                                                                                                                                                                                                                       | SHEET 1 OF 11 |
| APPROVED   | CP                                                                                                                                                                                                                                                                                   | TITLE                                                                                                                                                                                                                                                                                       | SCALE         |
| DE APPR.   | CP                                                                                                                                                                                                                                                                                   | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                          | NTS           |
| DATE       | 16.01.14                                                                                                                                                                                                                                                                             | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC<br/> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |               |

RELEASED  
2016-04-28  
ECN 16-96





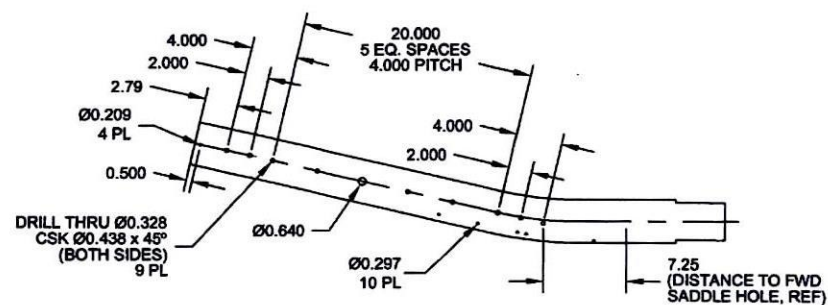
**D3391-011 FWD TUBE ASSEMBLY**  
ASSEMBLY DETAIL



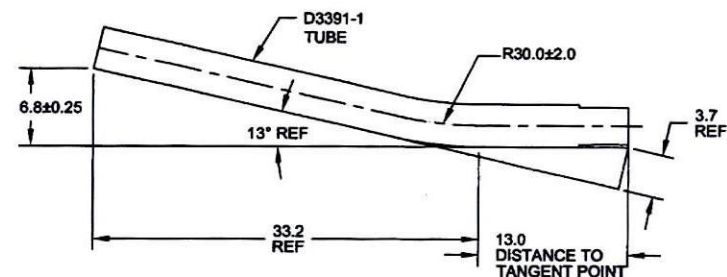
**DETAIL A**  
SCALE 2X

**D3391-011 FWD TUBE ASSEMBLY PARTS LIST**

| QTY<br>-011 | PART NUMBER   | DESCRIPTION       |
|-------------|---------------|-------------------|
| X           | D3391-011     | FWD TUBE ASSEMBLY |
| 1           | D3391-1       | TUBE              |
| 1           | D3401-041     | TOW CAP           |
| 9           | D3670-4200    | SPACER            |
| 4           | D3672-1       | WASHER            |
| 1           | D4095-051     | WEARSHOE          |
| 10          | AELS-1032-225 | INSERT            |
| 10          | AN3C4A        | BOLT              |
| 10          | NAS1149C0332R | WASHER            |



**D3391-011 DRILLING DETAIL**



**D3391-011 BENDING DETAIL**  
(MAKE FROM D3391-1)

|            |          |                                                                                                                                                                                                                                                                                            |               |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b><br>EUGENE, OR                                                                                                                                                                                                                                               |               |
| DRAWN      | ML       |                                                                                                                                                                                                                                                                                            |               |
| CHECKED    | CP       | DRAWING NO.<br>D3391                                                                                                                                                                                                                                                                       | REV. J        |
| MFG. APPR. |          |                                                                                                                                                                                                                                                                                            | SHEET 3 OF 11 |
| APPROVED   |          | TITLE<br>412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                | SCALE<br>NTS  |
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| DATE       | 16.01.14 |                                                                                                                                                                                                                                                                                            |               |

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INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
4 PL

# DETAIL B



INSTALL  
AELS-1032-225  
AFTER FINISH  
10 PL

D4095-051  
WEARSHOE

AN3C4A BOLT  
NAS1149C0332R WASHER  
6 PL

## D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH  
SIKAFLEX-241/-291

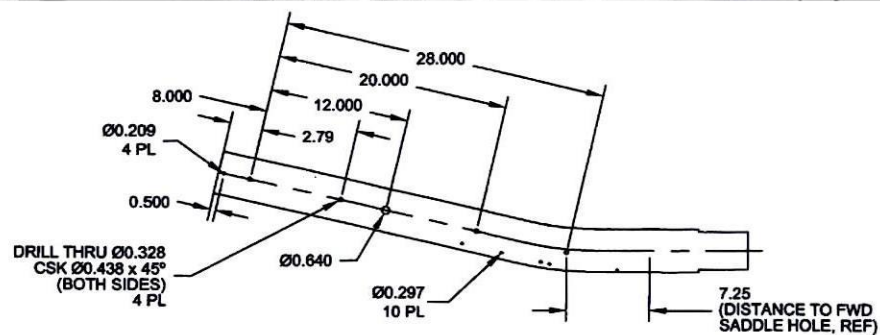
D3401-041  
TOW CAP

## DETAIL B SCALE 2X

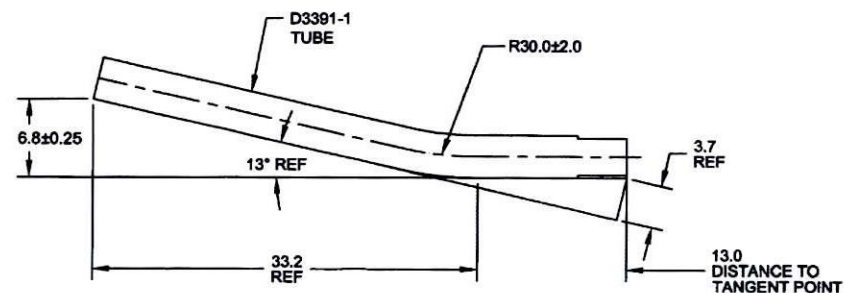
AN3C4A BOLT  
D3672-1 WASHER  
NAS1149C0332R WASHER  
4 PL

## D3391-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY<br>-021 | PART NUMBER   | DESCRIPTION       |
|-------------|---------------|-------------------|
| X           | D3391-021     | FWD TUBE ASSEMBLY |
| 1           | D3391-1       | TUBE              |
| 1           | D3401-041     | TOW CAP           |
| 4           | D3670-4200    | SPACER            |
| 4           | D3672-1       | WASHER            |
| 1           | D4095-051     | WEARSHOE          |
| 10          | AELS-1032-225 | INSERT            |
| 10          | AN3C4A        | BOLT              |
| 10          | NAS1149C0332R | WASHER            |



## D3391-021 DRILLING DETAIL

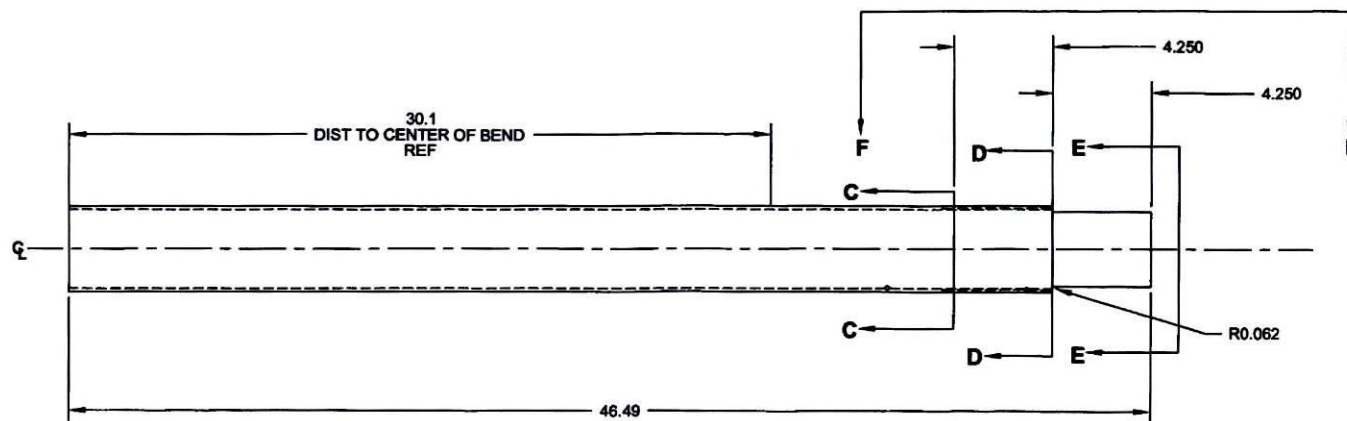


## D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

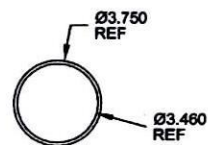
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|                                                                                                                                                                                                                                     |           |                                             |               |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------------------------------------------|---------------|
| DESIGN                                                                                                                                                                                                                              | PH        | <b>DART AEROSPACE USA, INC</b>              |               |
| DRAWN                                                                                                                                                                                                                               | ML        | EUGENE, OR                                  |               |
| CHECKED                                                                                                                                                                                                                             | CP        | DRAWING NO.                                 | REV.          |
| MFG. APPR.                                                                                                                                                                                                                          | <i>CP</i> | D3391                                       | SHEET 4 OF 11 |
| APPROVED                                                                                                                                                                                                                            | <i>CP</i> | TITLE                                       | SCALE         |
| DE APPR.                                                                                                                                                                                                                            | <i>CP</i> | 412 FLOAT SKIDTUBE                          | NT            |
| DATE                                                                                                                                                                                                                                | 16.01.14  | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |               |
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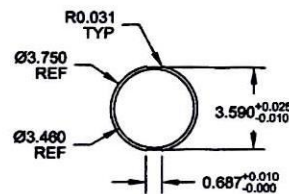




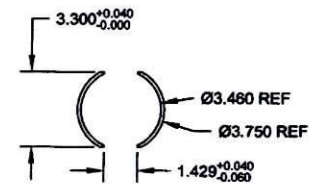
**D3391-1 TUBE**  
(MAKE FROM D8013-047 SKIDTUBE MATERIAL)



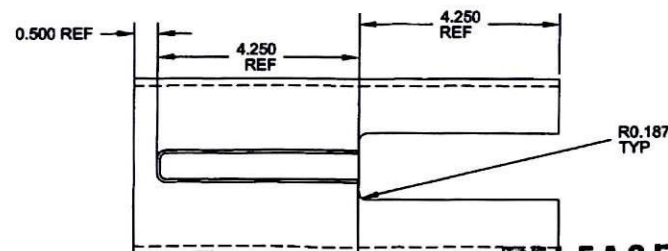
**SECTION C-C**



**SECTION D-D**



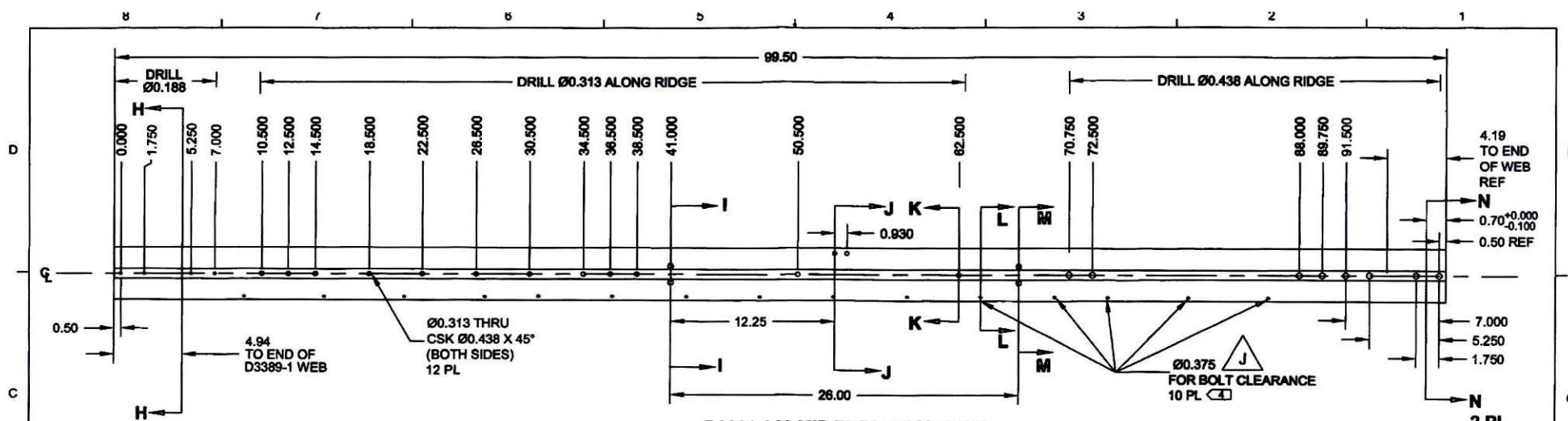
**SECTION E-E**



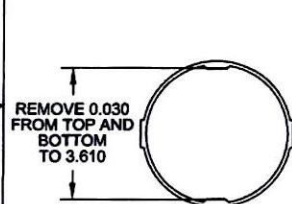
**VIEW F-F**  
SCALE 2X

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2016-04-28

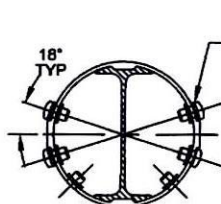
|            |          |                                                                                                                                                                                                                                                                                                   |               |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                                    |               |
| DRAWN      | ML       | EUGENE, OR                                                                                                                                                                                                                                                                                        |               |
| CHECKED    | CP       | DRAWING NO.                                                                                                                                                                                                                                                                                       | REV. J        |
| MFG. APPR. | 22       | D3391                                                                                                                                                                                                                                                                                             | SHEET 5 OF 11 |
| APPROVED   | 21       | TITLE                                                                                                                                                                                                                                                                                             | SCALE         |
| DE APPR.   | 21       | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                                | NTS           |
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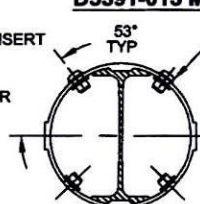
### D3391-013 MID TUBE ASSEMBLY



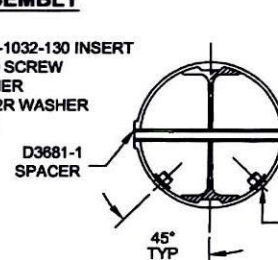
**SECTION H-H**  
SCALE 2X



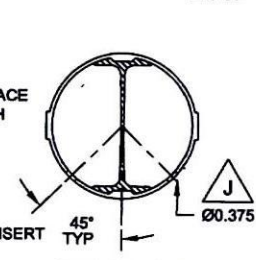
**SECTION I-I**  
SCALE 2X



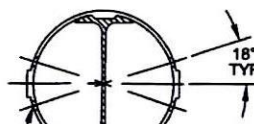
**SECTION J-J**  
SCALE 2X



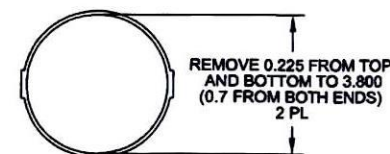
**SECTION K-K**  
SCALE 2X



**SECTION L-L**  
SCALE 2X



**SECTION M-M**  
SCALE 2X



**SECTION N-N**  
SCALE 2X

### D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER   | DESCRIPTION       |
|-----|---------------|-------------------|
| X   | D3391-013     | MID TUBE ASSEMBLY |
| 1   | D2500-1-100   | EXTRUSION         |
| 1   | D3389-1       | WEB               |
| 4   | D3672-1       | WASHER            |
| 4   | D3672-3       | WASHER            |
| 12  | D3681-1       | SPACER            |
| 24  | AELS-1032-130 | INSERT            |
| 4   | ALS4-428-165  | INSERT            |
| 4   | MS27039C1-09  | SCREW             |
| 4   | MS27039C4-08  | SCREW             |
| 4   | NAS1149C0332R | WASHER            |
| 4   | NAS1149C0432R | WASHER            |



### D3391-013 MID TUBE ASSEMBLY

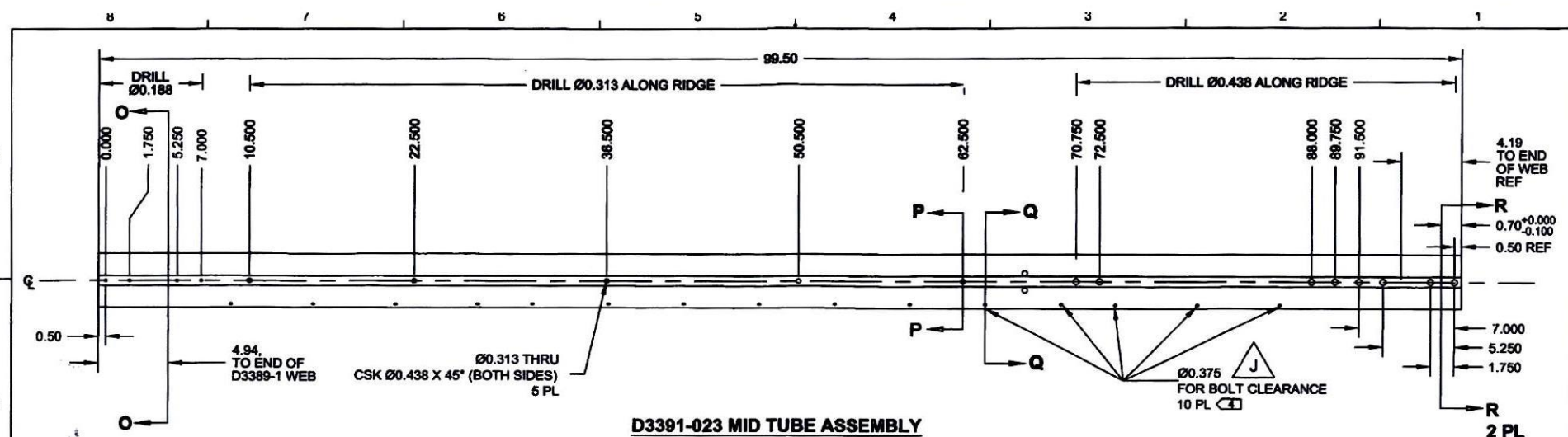
- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

| DESIGN     |    | PH       |          | DART AEROSPACE USA, INC |               |
|------------|----|----------|----------|-------------------------|---------------|
| DRAWN      | ML | CHECKED  | CP       | EUGENE, OR              |               |
| MFG. APPR. |    | APPROVED |          | DRAWING NO.             | REV. J        |
| DE APPR.   |    | DATE     | 16.01.14 | D3391                   | SHEET 6 OF 11 |
|            |    |          |          | TITLE                   | SCALE         |
|            |    |          |          | 412 FLOAT SKIDTUBE      | NTS           |

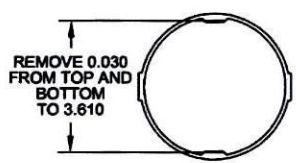
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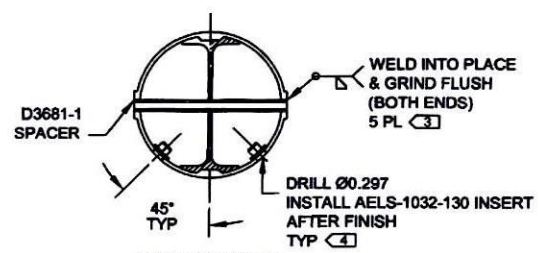




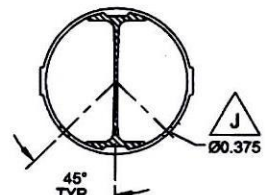
**D3391-023 MID TUBE ASSEMBLY**



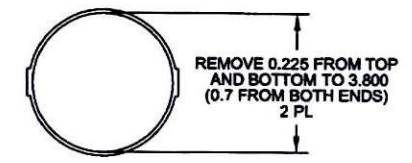
**SECTION O-O**  
SCALE 2X



**SECTION P-P**  
SCALE 2X



**SECTION Q-Q**  
SCALE 2X



**SECTION R-R**  
SCALE 2X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

| QTY -023 | PART NUMBER   | DESCRIPTION       |
|----------|---------------|-------------------|
| X        | D3391-023     | MID TUBE ASSEMBLY |
| 1        | D2500-1-100   | EXTRUSION         |
| 1        | D3389-1       | WEB               |
| 5        | D3681-1       | SPACER            |
| 20       | AELS-1032-130 | INSERT            |

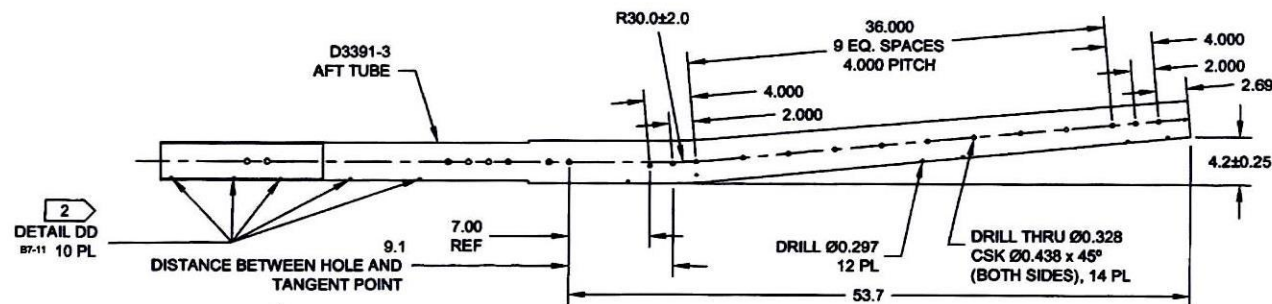
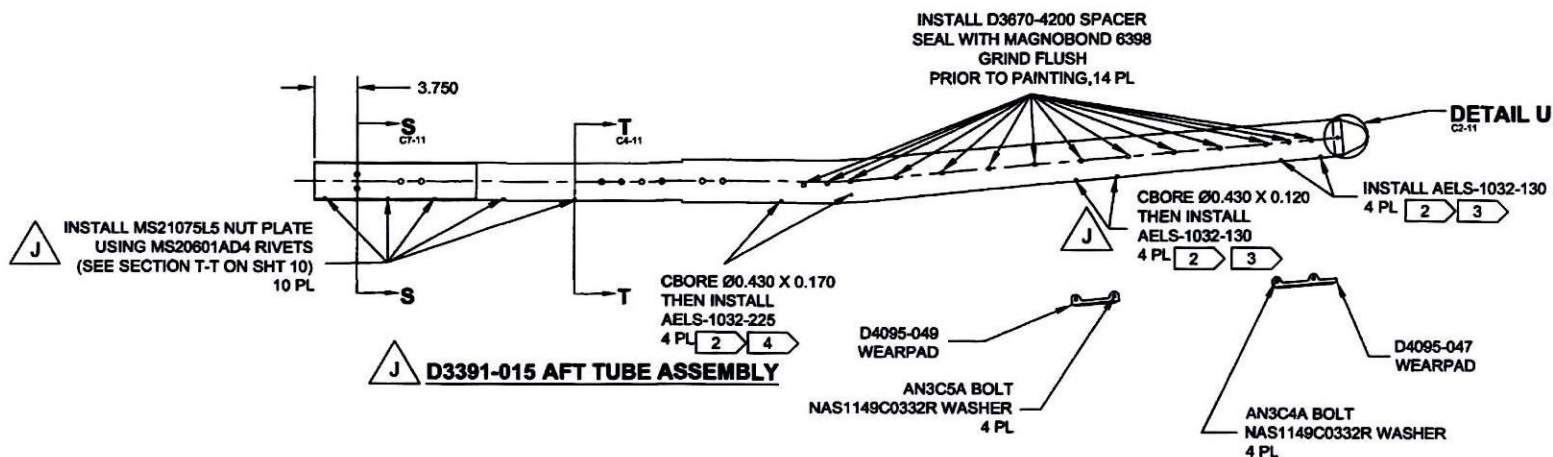


**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

|            |          |                                             |               |
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| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>              |               |
| DRAWN      | ML       | EUGENE, OR                                  |               |
| CHECKED    | CP       | DRAWING NO.                                 | REV. J        |
| MFG. APPR. |          | D3391                                       | SHEET 7 OF 11 |
| APPROVED   |          | TITLE                                       | SCALE         |
| DE APPR.   |          | 412 FLOAT SKIDTUBE                          | NTS           |
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2016-04-28



# D3391-015 AFT TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER   | DESCRIPTION         |
|-----|---------------|---------------------|
| X   | D3391-015     | AFT TUBE ASSEMBLY   |
| 1   | D2648         | AFT CAP             |
| 1   | D3391-3       | AFT TUBE            |
| 14  | D3670-4200    | SPACER              |
| 2   | D3672-1       | WASHER              |
| 1   | D4095-049     | WEARPAD             |
| 1   | D4095-047     | WEARPAD             |
| 8   | AELS-1032-130 | INSERT              |
| 4   | AELS-1032-225 | INSERT              |
| 4   | ALS4-428-165  | INSERT              |
| 6   | AN3C4A        | BOLT                |
| 4   | AN3C5A        | BOLT                |
| 20  | MS20601AD4    | RIVET, BLIND        |
| 10  | MS21075L5     | NUT PLATE, FLOATING |
| 10  | NAS1149C0332R | WASHER              |

## NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

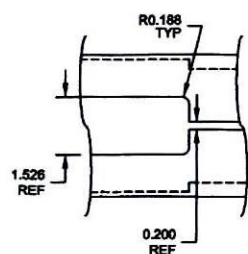
## BENDING AND DRILLING DETAIL

RELEASED  
2016-04-28

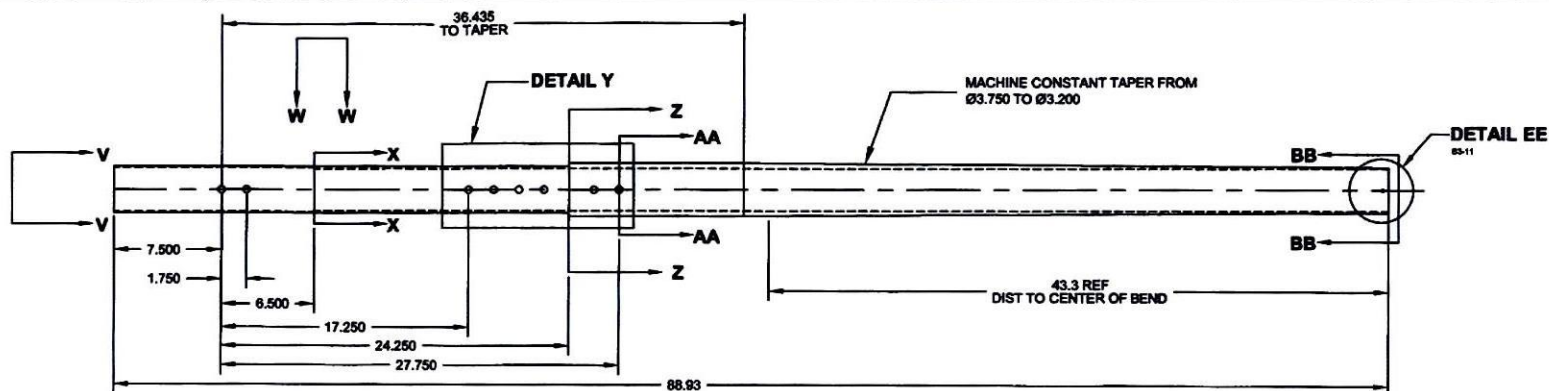
|            |                    |                                                                                                                                                                                                                                                                                              |               |
|------------|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PH                 | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                               |               |
| DRAWN      | ML                 | EUGENE, OR                                                                                                                                                                                                                                                                                   |               |
| CHECKED    | CP                 | DRAWING NO.                                                                                                                                                                                                                                                                                  | REV.          |
| MFG. APPR. | <i>[Signature]</i> | D3391                                                                                                                                                                                                                                                                                        | SHEET 8 OF 11 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                        | SCALE         |
| DE APPR.   | <i>[Signature]</i> | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                           | NTS           |
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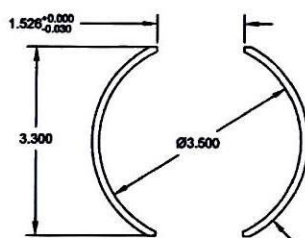




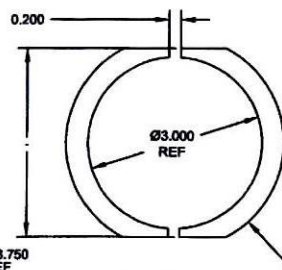
**VIEW W-W**  
SCALE 4X



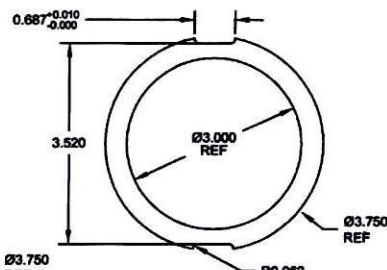
**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D8014-000)



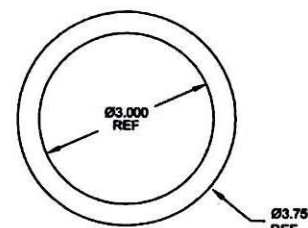
**SECTION V-V**  
SCALE 4X



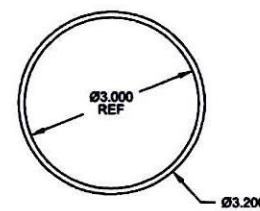
**SECTION X-X**  
SCALE 4X



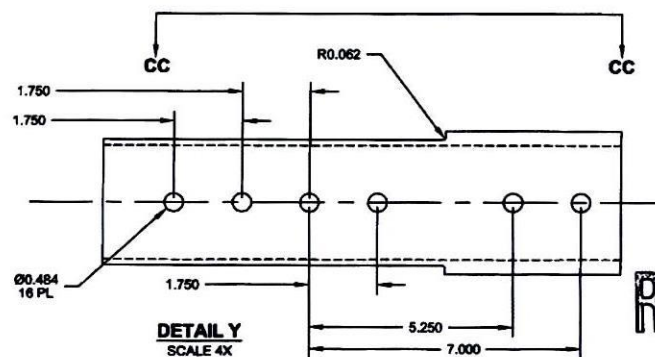
**SECTION Z-Z**  
SCALE 4X



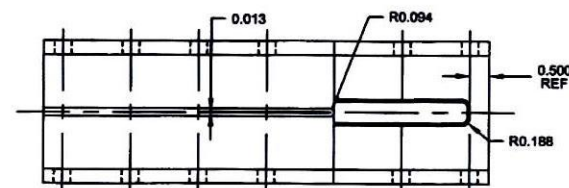
**SECTION AA-AA**  
SCALE 4X



**SECTION BB-BB**  
SCALE 4X



**DETAIL Y**  
SCALE 4X

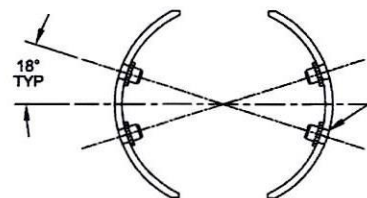


**VIEW CC-CC**

|            |            |                                                                                                                                                                                                                                                                                        |                |
|------------|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | PH         | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                         |                |
| DRAWN      | ML         | EUGENE, OR                                                                                                                                                                                                                                                                             |                |
| CHECKED    | CP         | DRAWING NO.                                                                                                                                                                                                                                                                            | REV.           |
| MFG. APPR. | <i>2/2</i> | D3391                                                                                                                                                                                                                                                                                  | SHEET 10 OF 11 |
| APPROVED   | <i>2/2</i> | TITLE                                                                                                                                                                                                                                                                                  | SCALE          |
| DE APPR.   | <i>2/2</i> | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                     | NT             |
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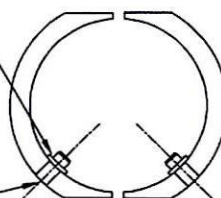


**SECTION S-S**  
SCALE 5X

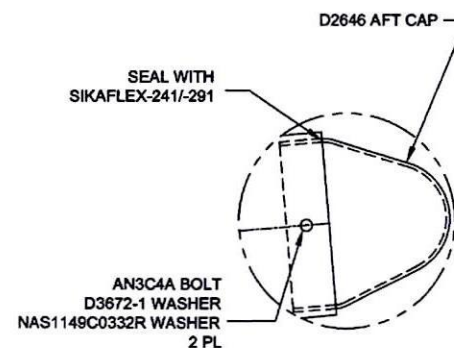
MS21075L5 NUTPLATE  
REF

DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL

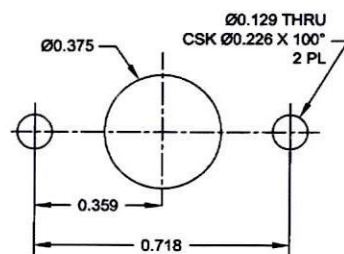
USE DT8217 DRILL TEMPLATE  
TO LOCATE HOLES AND OPEN  
TO Ø0.375



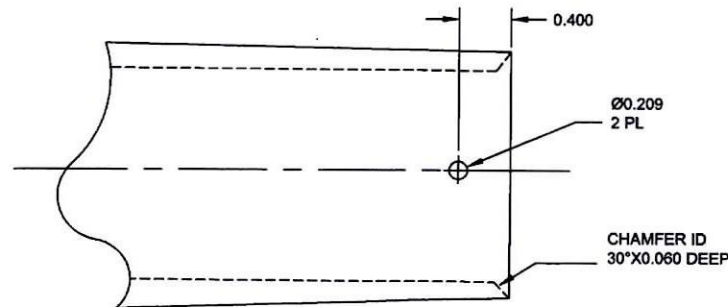
**SECTION T-T**  
SCALE 5X



**DETAIL U**  
SCALE 5X



**DRILLING DETAIL DD**  
SCALE 10X



**DETAIL EE**  
SCALE 2X

**NOTES:**  
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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2016-04-28

|            |                                                                                       |                                                                                                                                                                                                                                                                                     |                |
|------------|---------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | PH                                                                                    | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                      |                |
| DRAWN      | ML                                                                                    | EUGENE, OR                                                                                                                                                                                                                                                                          |                |
| CHECKED    | CP                                                                                    | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. J         |
| MFG. APPR. |  | D3391                                                                                                                                                                                                                                                                               | SHEET 11 OF 11 |
| APPROVED   |  | TITLE                                                                                                                                                                                                                                                                               | SCALE          |
| DE APPR.   |  | AFT TUBE ASSEMBLY                                                                                                                                                                                                                                                                   | NTS            |
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Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO038670**

**Supplier:** ATE003-VC  
Atelier Debosselage  
358 Principale  
Calumet  
QC  
J0V 1B0 Canada  
Phone: 819 242 5633

**PO No:** PO038670

**PO Date:** 12/18/17

**Due Date:** 12/18/17

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Lavoie, Chantal  
clavoie@dartaero.com

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pynt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

## **Items**

| Line Item | Job      | Part      | Description       | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
|-----------|----------|-----------|-------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 166956-B | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 2         | 166956-A | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 3         | 166956-E | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 4         | 166956-F | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 5         | 166956   | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 6         | 166956-D | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 7         | 168393   | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 8         | 166956-G | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |
| 9         | 166956-C | D3391-023 | Mid Tube Assembly | Firmed | 12/18/17 | 1 pcs          | 0 pcs             | 1 pcs   | \$125.00/pcs     | \$125.00       |

**Grand Total: \$1,125.00**

## **Order Notes**

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 12/18/17 7:52 AM dart.lavoie.chantal